

Work Order ID 80842

Thursday, March 01, 2012 12:31:25 PM

80842Ship Friday
March 9th
Page 1

Item ID: D2989-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Lid Assembly

Start Date: 3/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/7/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-03-01*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: *M115778*

*** PLEASE NOTE****

IF MAKING -043A :

ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER

DSI9473

SD 12-03-08 1x

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

→ 12.03.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Revision ID:

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Required Date: 3/7/2012 Req'd Qty: 1.00

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N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

1X4 m-1 12/03/10

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg
D2989

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

131

Wing Walk as per dwg QSI005 4.4 Batch 120125 0.00***131***

HandFinish

Memo

0.00

Hand Finishing

Mask lid prior to spray paint black and wing walk as per dwg
A/R Spray paint black batch: 118114*1X8 m-12/03/10**1 A 12312**m120222**9:45
4000 F
10:13*

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 *ML 12/03/12*

141

Identify as per dwg & Stock Location: DS1 9250-011

0.00

141

Packaging

Memo

0.00

Packaging

1 *BR 12-3-12*

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

*ML 12/03/12**12-03-12*

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Picklist Print

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Page 1

3

Work Order ID: 80842
Parent Item: D2989-041
Parent Item Name: Basket Lid Assembly

Start Date: 3/1/2012 Required Date: 3/7/2012
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1 Rib		Manufactured	No			100	Each	9.0000	2	2		12.03.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				80163		8					2x		
				WA006		1							
				72297		1							
✓ D2506 Label Plate		Manufactured	No			100	Each	11.0000	1	1		12.03.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		11							
				74142		1					1x		
				79197		10							
✓ D2512-7 Rib		Manufactured	No			100	Each	2.0000	1	1		12.03.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		2							
				71220		2					1x		
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	45.0000	2	2		12.03.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		45							
				69739		1							
				70766		2							
				77045		13					2x		
				77523		29							

W/O:		WORK ORDER CHANGES					
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Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 3/1/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D2989-13	Manufactured	No	100	Each	2.0000	2	
Rib							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			WA005		2		
			72410		2		
✓ D2989-19	Manufactured	No	100	Each	2.0000	2	2
Rib							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			WA006		2		
			72411		2		
✓ D3832-3	Manufactured	No	100	Each	3.0000	1	1
Mesh (Lid)							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			WA035		3		
			77520		3		
✓ D3833-3	Manufactured	No	100	Each	11.0000	2	2
Mesh (Lid End)							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			WA035		11		
			67460		11		
✓ D3836-041	Manufactured	No	100	Each	6.0000	1	1
Rib Assembly (Basket Lid, LH)							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			WA		6		
			77515		6		
✓ D3836-042	Manufactured	No	100	Each	6.0000	1	1
Rib Assembly (Basket Lid, RH)							
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
			WA005		6		
			77514		6		

12.03.07

2x

12.03.07

2x

12.03.08

1x

12.03.08

2x

12.03.07

1x

12.03.07

1x

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Shop Packet Print

Page 2

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Page 3

Work Order ID: 80842

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 3/1/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

D3852-041
Rib Assembly

Manufactured No

100 Each 4.0000 1

Location

Loc Qty

Loc Code

WA005

4

77512

4

12-03-07

1v

D3852-042
Rib Assembly

Manufactured No

100 Each 5.0000 1 1

Location

Loc Qty

Loc Code

WA

2

77513

2

WA005

3

66089

1

77513

2

12-03-07

1x

W/O:		WORK ORDER CHANGES					
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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2, REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED IN ANY OTHER MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

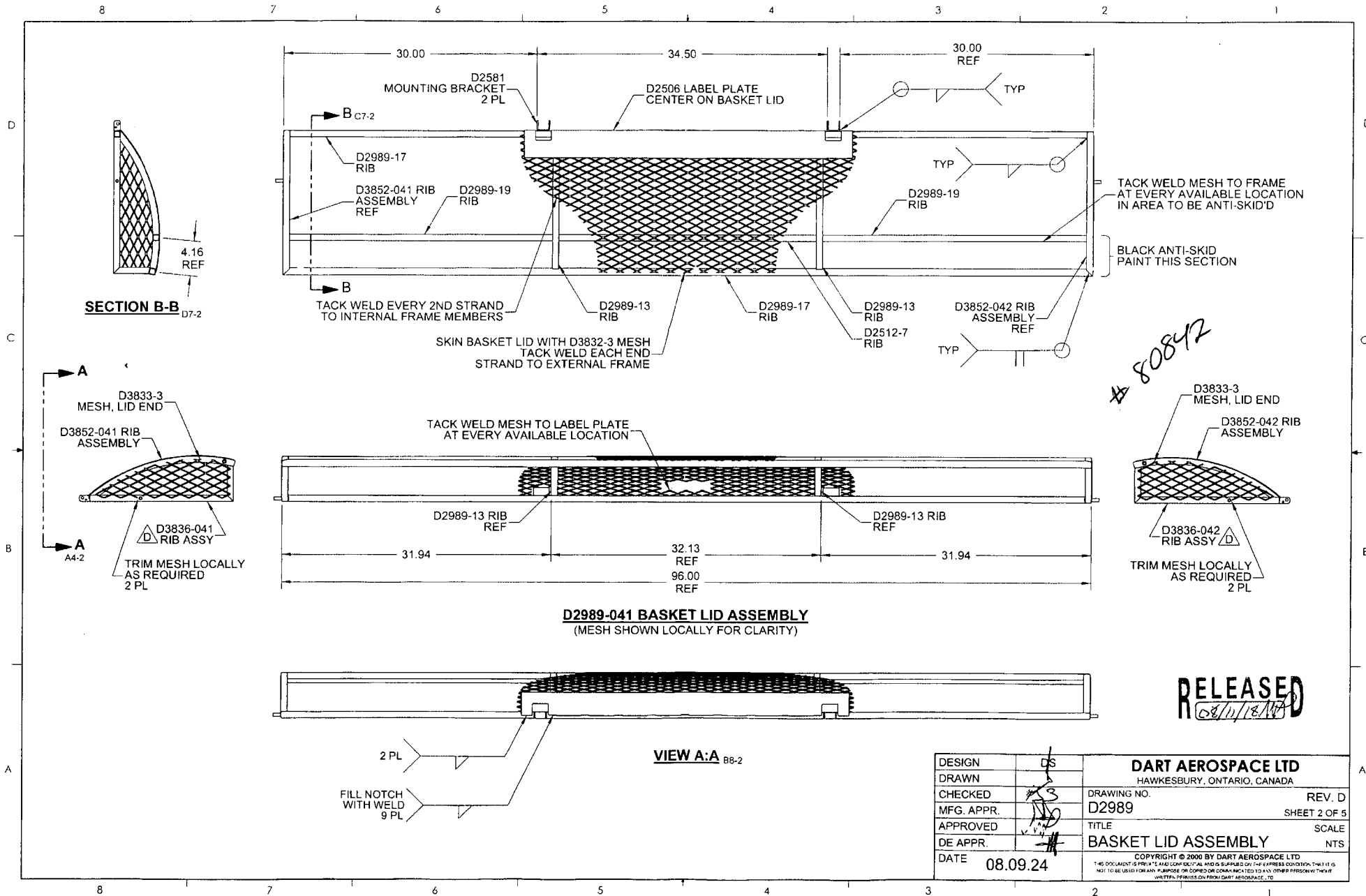
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
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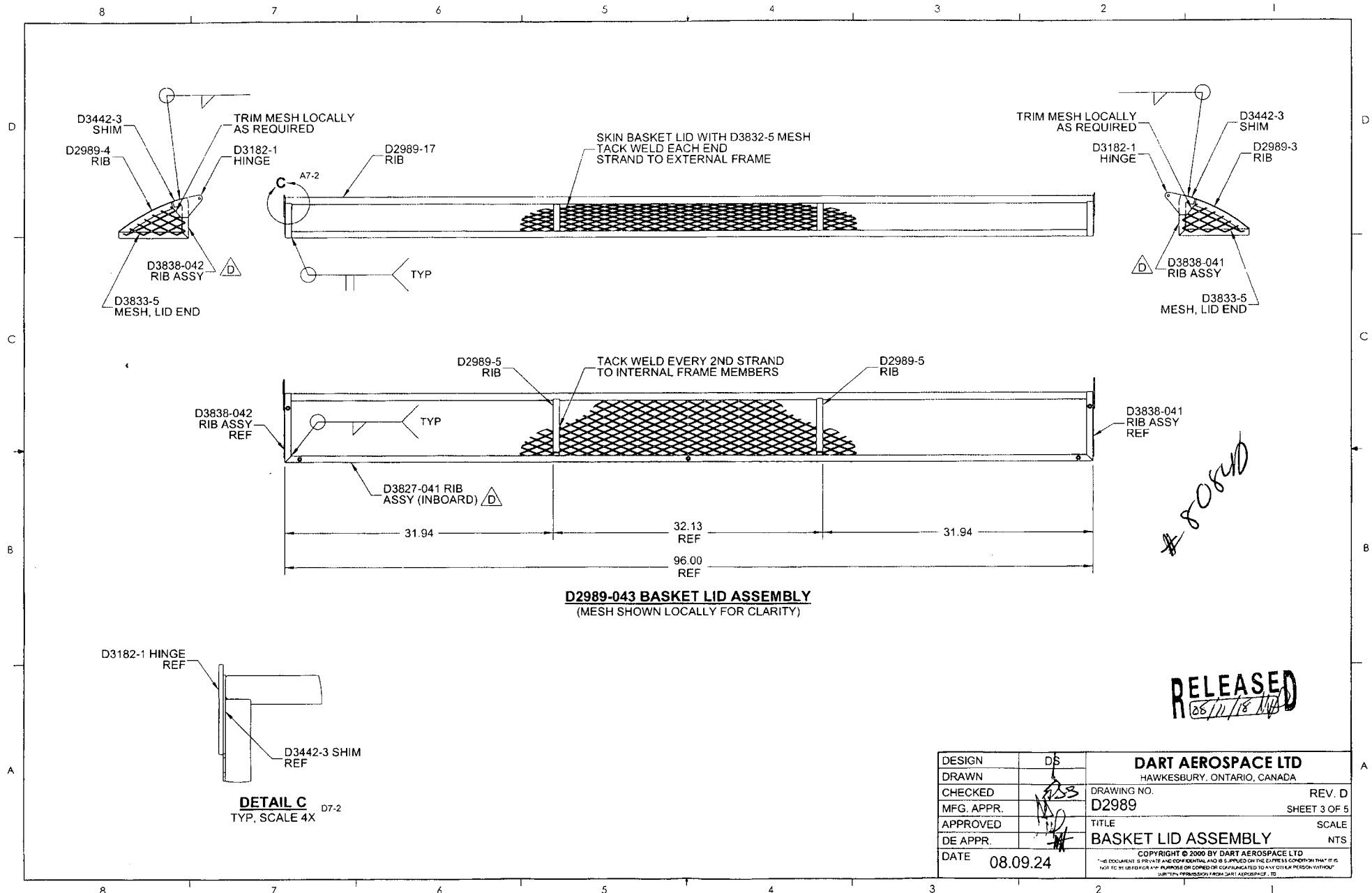
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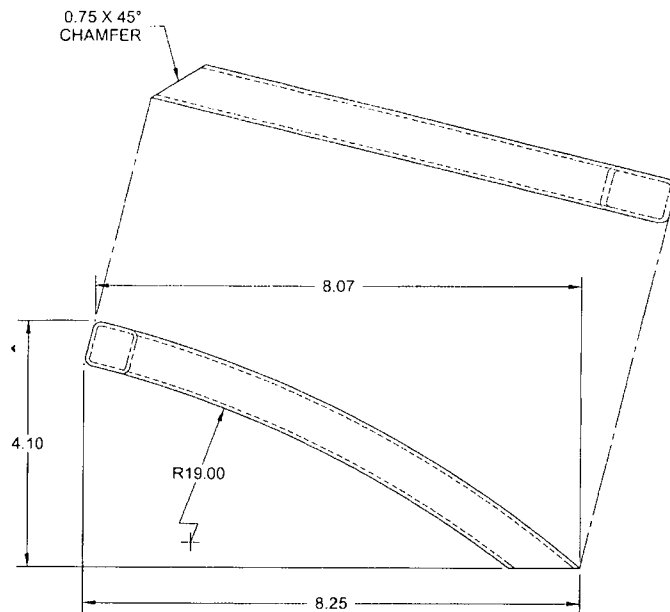
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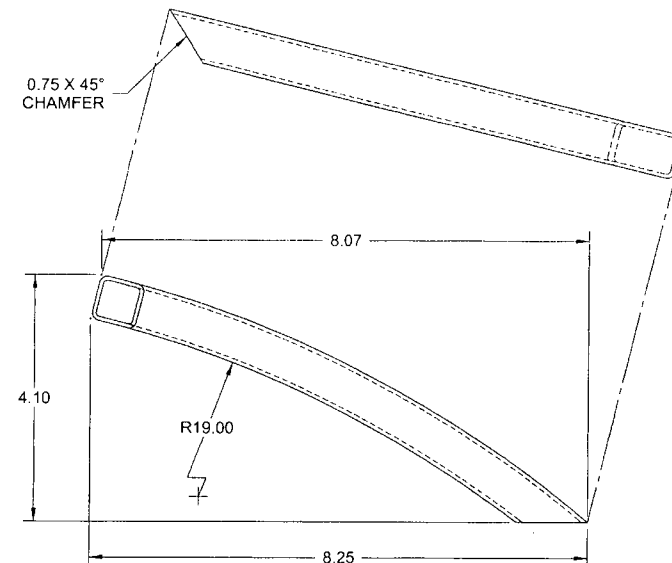
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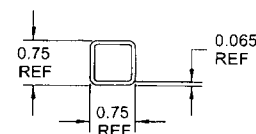


D2989-3 RIB



D2989-4 RIB

805410



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

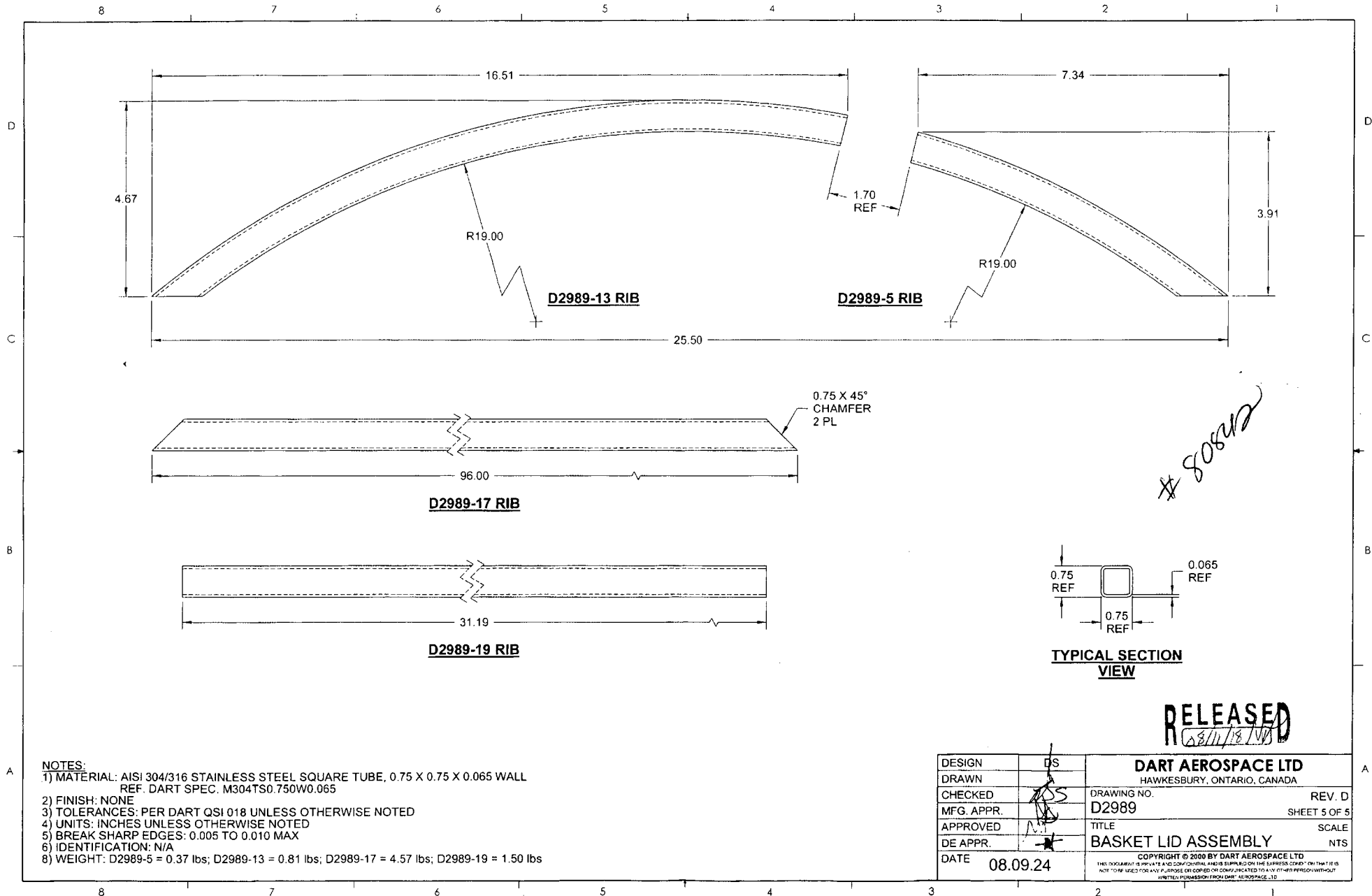
Dart Aerospace Ltd

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